

Date: Monday, 21/07/2008 10:53:29 AM
User: Julie Lecocq

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	SUPPORT ARM
Job Number	40683	Part Number	D31651
Estimate Number	11488	Drawing Number	D3165 REV A
P.O. Number		Project Number	N/A
This Issue	21/07/2008	Drawing Revision	A
Prsht Rev.	NC	Material	
First Issue	1/1	Due Date	10/08/2008
Previous Run	36522	Qty:	6
Written By		Um:	Each
Checked & Approved By	JLO 08.7.21		
Comment	Est. A 02.09.18 New issue KJ		
Additional Product			
Job Number:			
Seq. #:	Machine Or Operation:	Description:	
1.0	M6061T6B0500X05000 	6061-T6 Bar .500 x 5.00	
Comment: Qty.: 1.4963 f(s)/Unit Total: 8.9775 f(s) 6061-T6 Bar .50" x 5.0" Material: 6061-T6/T651 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) per (M6061T6B0500x5000) Batch M108586X2 M106182X1 JL 08/08/03 (6) (5)			
2.0	BAND SAW 	BAND SAW	
Comment: BAND SAW Cut Blank: (17.00" x 5.00") +/- 0.030" x 0.500" thick Grain along 17.000" Grain 08/08/03 (6) (5)			
3.0	HAAS1 	HAAS CNC VERTICAL MACHINING #1	
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA277 & Dwg D3165-1 Deburr & Tumble DWP 08/09/21 / JL 08/09/21			
4.0	QC2 	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE DWP 08/09/21 / JL 08/09/21			
5.0	QC8 	SECOND CHECK	
Comment: SECOND CHECK DWP 08/09/21 / JL 08/09/21			

WORK ORDER CHANGES

W/O:	DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	08-01-25	6.0	Change Eng location, Now in Machining	JSS	08-01-25	N/A		S 08/01/03

Part No: D3165-1 PAR #: N/A Fault Category: Prod / Machined ^{Parts} NCR: Yes No DQA: D Date: 08/10/03
 D205-633-015/025/026/024 QA: N/C Closed: D Date: 08/10/03

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/09/24	3.0	First part had wrong origine R.C. operator error. forget to move move after	J 08/09/24	Scrap and Replace Batch# <u>109025</u> Qty <u>4</u> - Make part easier	DSP 08/09/24	S 08/09/24	/	S 08/09/24
		drilling hole forgot to move after drilling the hole (mis-understood folio.	J 08/09/24	No need			/	S 08/09/24

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: SUPPORT ARM
Job Number: 40683		Part Number: D31651
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	SMALL FAB 1 <i>HAAS #1</i> <i>8/01/24</i>	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Engrave batch number as per Dwg D3165		<i>8/01/25</i>
7.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1 <i>M-F 08/01/26</i>
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		<i>6X</i>
8.0	POWDER COATING 	POWDER COATING <i>M108523</i> <i>6X</i>
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		<i>1:15</i> <i>START TIME: 3:20 O/P</i> <i>OVEN TEMPERATURE: 1:45</i> <i>M-F 08/01/26</i>
9.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION <i>8/9/24</i> <i>SQ 6X</i>
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
10.0	PACKAGING 1 	PACKAGING RESOURCE #1 <i>ISX 8/9/24</i> <i>SX SY</i>
Comment: PACKAGING RESOURCE #1		
11.0	QC21 	FINAL INSPECTION/W/O RELEASE <i>08/10/02</i> <i>MF 08-10-01</i>
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion 		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3065-5DART AEROSPACE LTD	Work Order:	40683
Description: Support Arm	Part Number:	D3165-1
Inspection Dwg: D3165	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x First Article Prototype

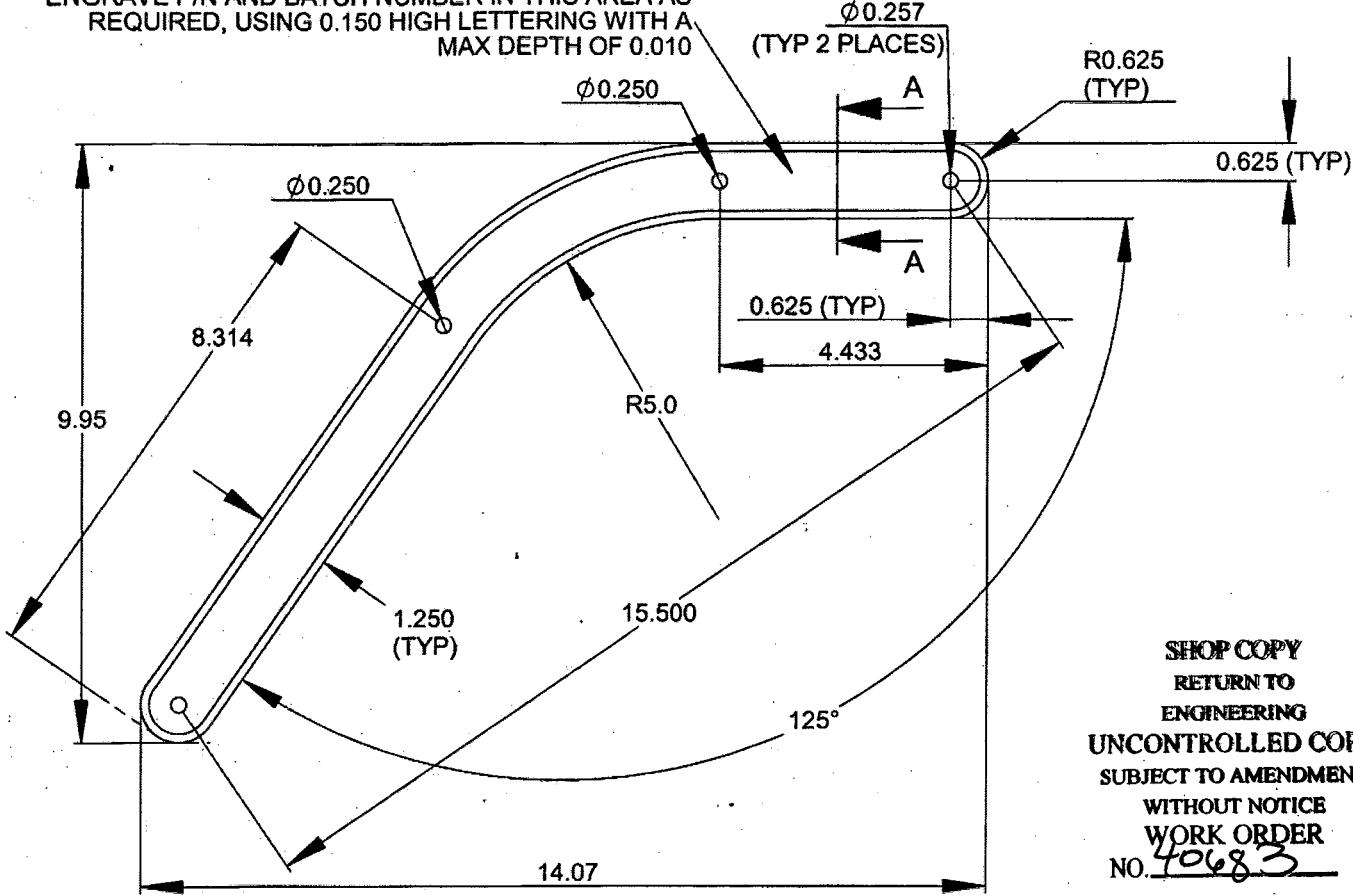
Measured by:	DJP	Audited by:	SS	Prototype Approval:	N/A
Date:	08/09/24	Date:	08/09/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	<i>[Signature]</i>

DART

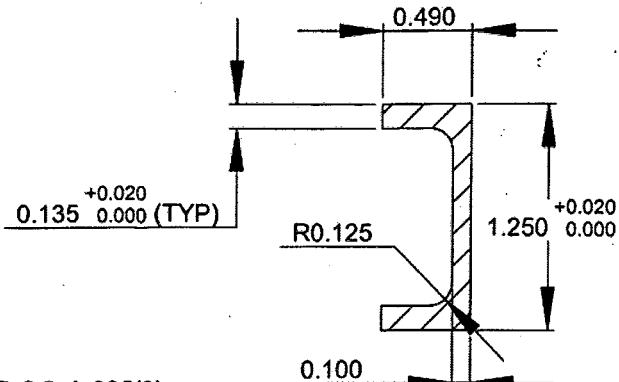
DESIGN <i>UP</i>	DRAWN BY <i>QP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3165	REV. A SHEET 1 OF 1
DATE 02.07.09	TITLE SUPPORT ARM	SCALE 1:3	
A	02.07.09	NEW ISSUE	

ENGRAVE P/N AND BATCH NUMBER IN THIS AREA AS
REQUIRED, USING 0.150 HIGH LETTERING WITH A
MAX DEPTH OF 0.010



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40683

RELEASED
02.08.07



D3165-1 SUPPORT ARM

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
PER M6061T6B
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SECTION A-A
SCALE (1 : 1)

